

50

Thursday, 11/15/2007 7:31:38 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B AFT X-TUBE
Job Number : 35725
Estimate Number : 12347
P.O. Number : N/A Part Number : D206667201
This Issue : 11/15/2007 S.O. No. : N/A Drawing Number : D206-667-241 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : B
Previous Run : 30443 Material : N/A
Written By : Due Date : 12/10/2007 Qty: 1 Um: Each
Checked & Approved By : JA 07.11.15
Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG002

2.0

D6003102

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6003-102

Crosstube

B23967

Check OD = 2.250"; ID = 1.380"

J.F. 07/11/28

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

J.F. 07/11/28

①

4.0

QC1

INSPECT ALL DIM TO DIM SHEET


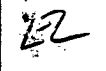
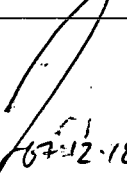

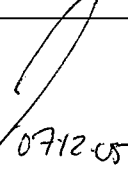


Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/11/28 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.12.04	11	Height +0.23, Half spans are -0.18/-0.12" One angle is -0.1° DIMS ARE IN REF TO NOMINAL DIMS, SEE DIM SHEET	 07.12.04 p QSI 042	PART ACCEPTABLE. ENSURE HOLES DRILLED AS FAR POSSIBLE UP AS POSSIBLE	 7-12-18	 07.12.18	 07.12.04 p QSI 042	 07.12.05

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 7:31:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/11/28 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/11/28

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/11/28 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM
07-11-29

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AD
07-11-29

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM
07-11-29

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

EL 7-12-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	4						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

SR/EL

7-12-7

AWM 07-12-10

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 07-12-10



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/12/13 (X)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5299

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207112117 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

PC 4/12/17 (L)

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

10-12-18

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

07-12-18

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ml 07 12 18 (1)

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total: 1.3525 f(s) (cut to 4")

Pick:

Qty Part number Description

Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

05656

ml 07 12 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34062

ml 07 12 18

24.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

103478

ml 07 12 18

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

ml 07 12 18 (1)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/2/12/21 (X)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M105408 SP

29.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-043

Nut Plate

28918

7/12/27 SP (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2872045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-045 Nut Plate 28919 *SP*

31.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-10A Bolt M104746 *SP*

32.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-30A Bolt M103641 *SP*

33.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

20 AN960JD516 Washer M104156 *SP*

34.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 MS21042L5 NUT M105430 *7/12/27 SP*

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/12/27 SP
3 M105940
7/12/27 SP
7/12/27 SP
7/12/27 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 7:31:38 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 35725

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location: _____

PPP Rev: _____

B

1/12/27 SD (rx)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/03

Job Completion



min 2008/1/2
U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

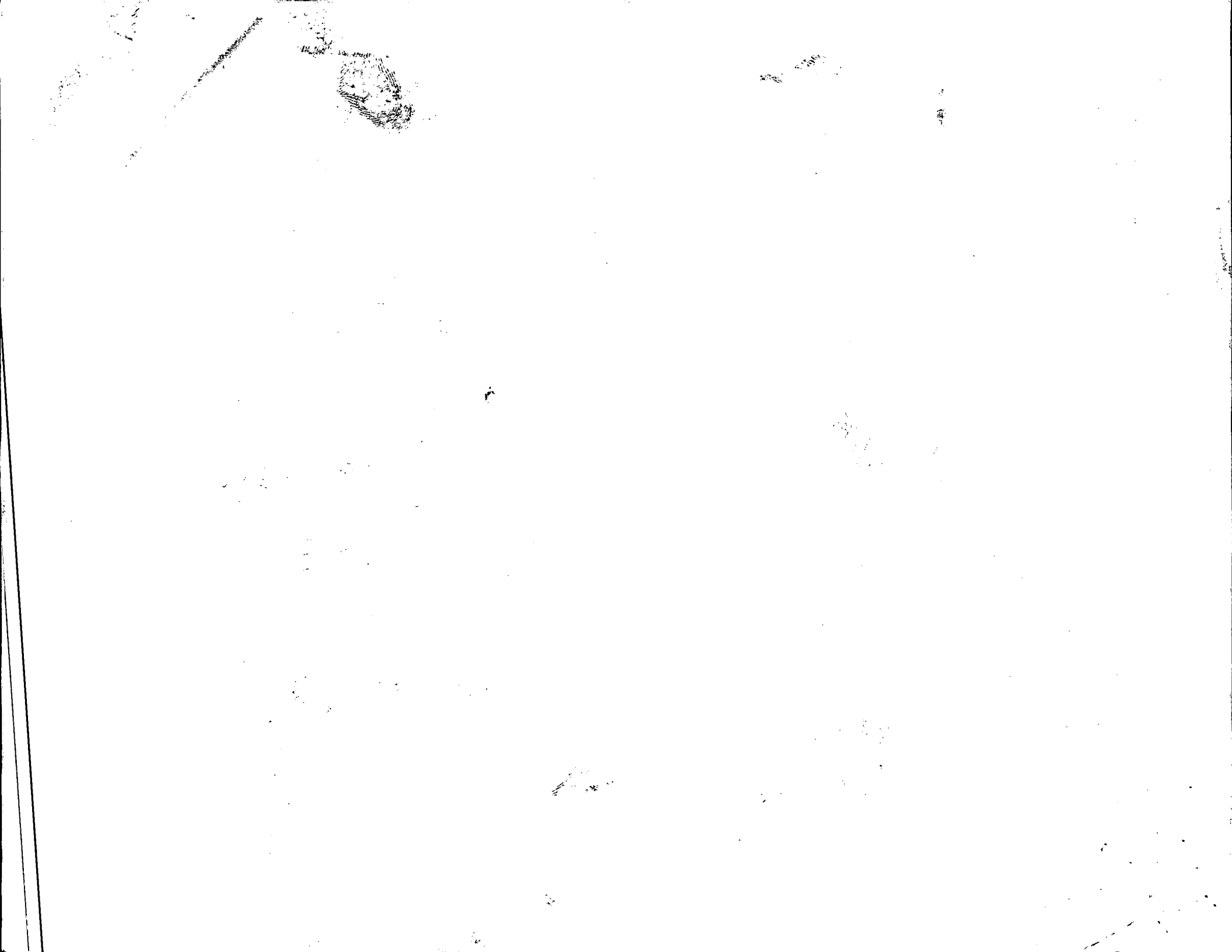
DART AEROSPACE LTD	Work Order: 35725
Description: Crosstube Assembly	Part Number: D206-667-241
Inspection Dwg: D206-667-241 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

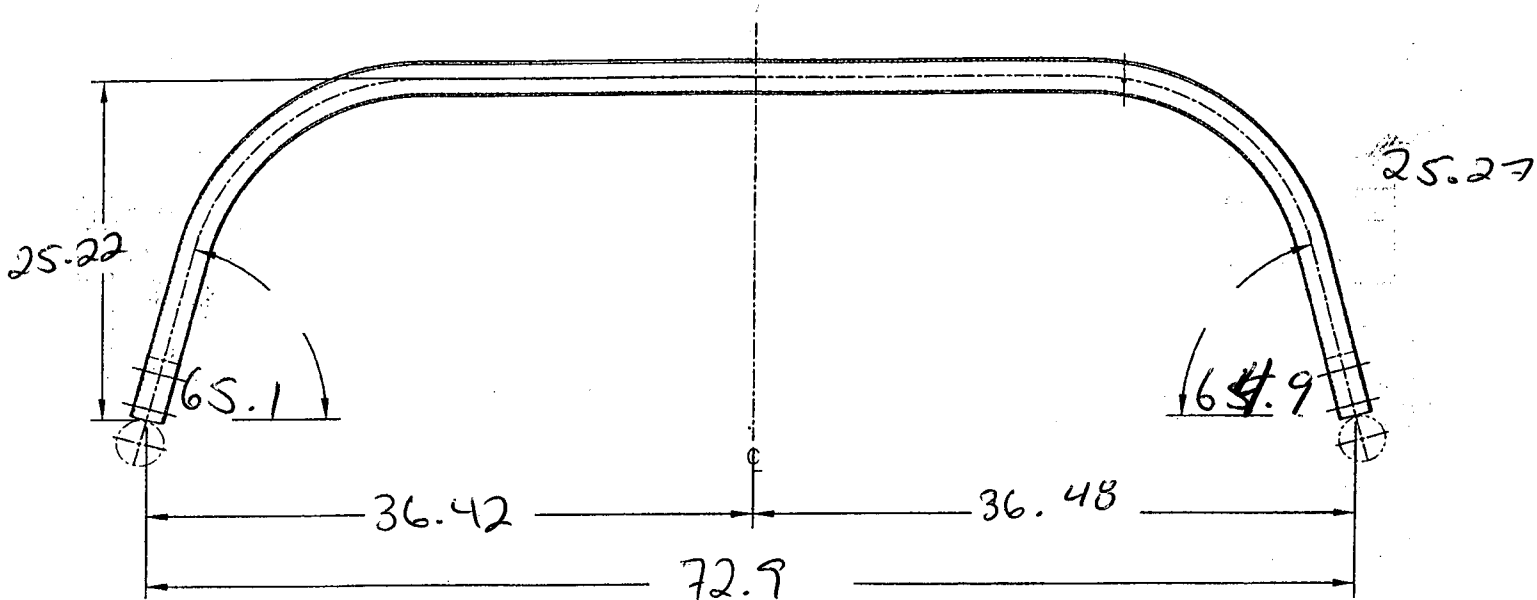
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	30° x .500"	✓			
	0.250	+/-0.010	.255"	✓			
	2.240	+0.005/-0.000	2.245"	✓			
	4.438	+/-0.030	4.459"	✓			
	1.780	+0.005/-0.000	1.785"	✓			
	R0.063	+/-0.010	R0.063"	✓			
	1.851	+0.005/-0.000	1.856"	✓			
	1.928	+0.005/-0.000	1.933"	✓			
	2.005	+0.005/-0.000	2.009"	✓			
	2.082	+0.005/-0.000	2.086"	✓			
	2.159	+0.005/-0.000	2.162"	✓			
	2.190	+0.005/-0.000	2.192"	✓			
SIDE B	30° x 0.500	+/-0.010	30° x .500"	✓			
	0.250	+/-0.010	.255"	✓			
	2.240	+0.005/-0.000	2.245"	✓			
	4.438	+/-0.030	4.445"	✓			
	1.780	+0.005/-0.000	1.785"	✓			
	R0.063	+/-0.010	R0.063"	✓			
	1.851	+0.005/-0.000	1.856"	✓			
	1.928	+0.005/-0.000	1.933"	✓			
	2.005	+0.005/-0.000	2.009"	✓			
	2.082	+0.005/-0.000	2.087"	✓			
	2.159	+0.005/-0.000	2.164"	✓			
	2.190	+0.005/-0.000	2.194"	✓			
	100.60	+/-0.020	100.600	✓			

Measured by: J.F.	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/11/28	Date: 07/11/28	Date:	N/A
Rev	Date	Change	Revised by Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



DART AEROSPACE LTD		Work Order:	35725
Description: Crosstube High Aft (206B)		Part Number:	D206-667-201
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	24.98	25.10
1/2 Span	36.54	36.66
Angle	65	67
Total Span	73.08	73.32



Comments
- height is un-even
- Tube acceptable per Eng approval. See PTO on w/d

QC15 Inspection	
Date	17.12.06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 #

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

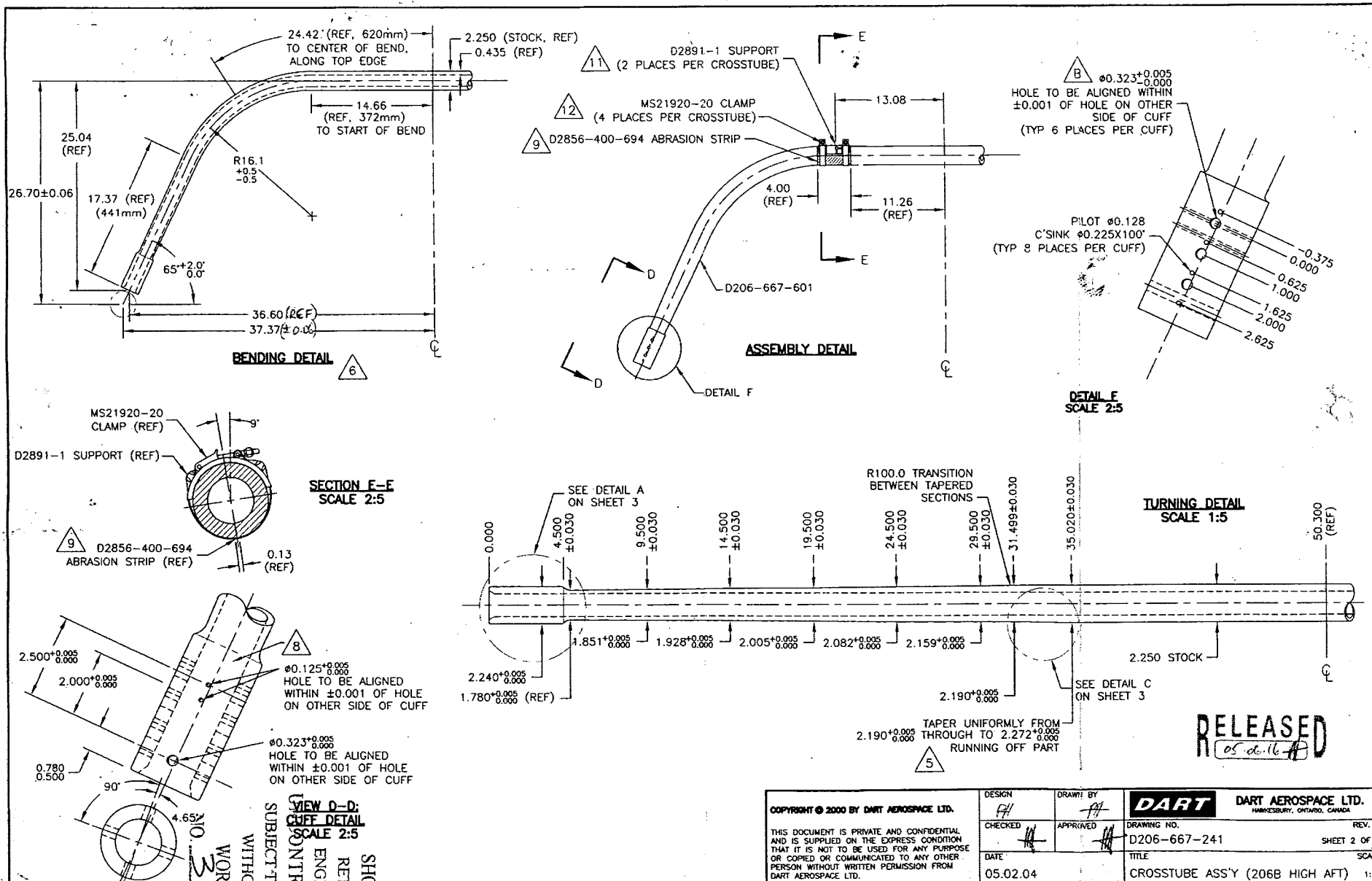
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

UNCONTROLLED COPY
ENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35725

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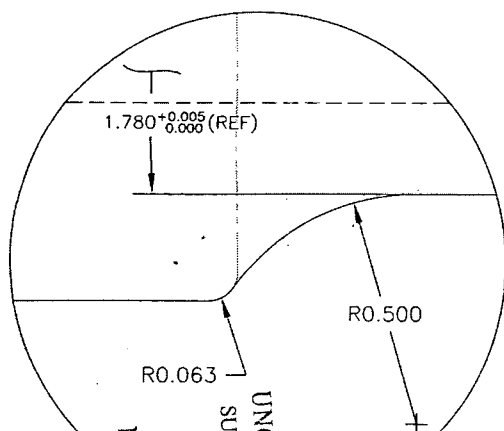
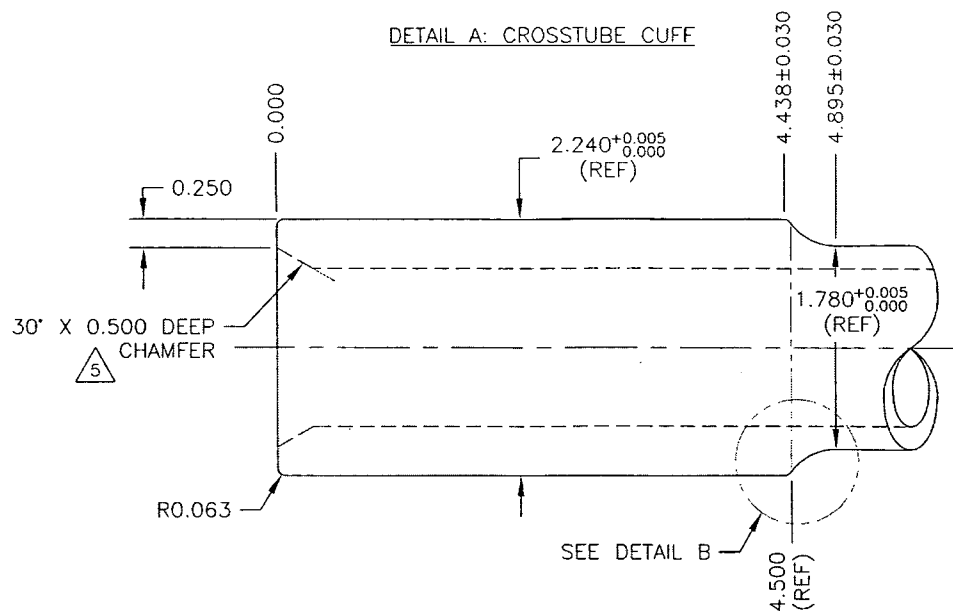


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DATE		05.02.04		DRAWING NO.	REV. B
				D206-667-241	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH AFT)	1:10

SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 35725

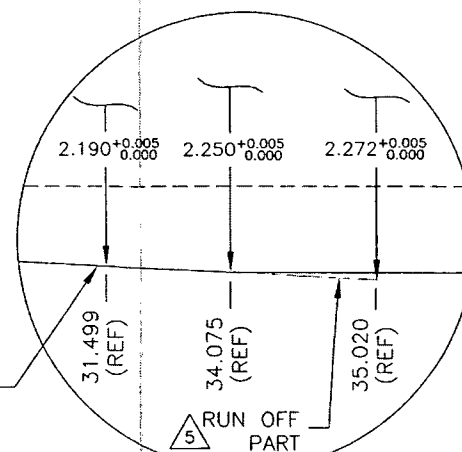
RELEASED
05-06-16

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35725

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
		DATE	05.02.04			D206-667-241	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206B HIGH AFT)	1:1



LIQUID PENETRANT TEST REPORT

P - 7-1055

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TIME AM ☐ PM ☐

CLIENT DART AREOSPACE

DATE DEC. 14, 2007

ATTENTION LINDA LACELLE

ACUREN JOB NO. 188-7-01055

ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT.

PO/VO No. 5299

WORK LOCATION HAWKESBURY

ACCEPTANCE STD. ASTM 1417/QSI-038

REV./DATE 2005

PROJECT 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES

ITEM(S) EXAMINED JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-0002-02 REV./DATE

Part No. D206667201, D206667203, D212664101, D206667103 Material ALODYNED ALUMINUM Thickness
Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

Method	<input checked="" type="checkbox"/> Fluorescent	<input type="checkbox"/> Visible	<input checked="" type="checkbox"/> Water Wash	<input type="checkbox"/> Solvent Removable	<input type="checkbox"/> Post Emulsified		
Family Brand	MAGNAFLUX		Black Light S/N	8178	<input checked="" type="checkbox"/> Output > 1000 μ W/cm ²	<input checked="" type="checkbox"/> Ambient < 2 fc	
Penetrant	ZL67	Minimum Dwell time	45	Min.	Lighting Equip.	<input checked="" type="checkbox"/> Flashlight <input type="checkbox"/> Troublelight	<input checked="" type="checkbox"/> Output > 100 fc @ surface
Penetrant Remover	H20	Minimum Dry time	>10	Min.	Other		
Developer	SKDS2	Minimum Dwell time	10	Min.	Light Meter S/N		Cal Due Date MAR 08
Developer Type	<input checked="" type="checkbox"/> Non Aqueous	<input type="checkbox"/> Aqueous	<input type="checkbox"/> Dry				

TEST SURFACE

Surface Condition	<input checked="" type="checkbox"/> As Ground	<input type="checkbox"/> As Welded	<input checked="" type="checkbox"/> Machined	<input type="checkbox"/> Shot Blasted	<input type="checkbox"/> Clean Bare Metal
Surface Temperature	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☐ IMPERIAL)

item	Comments	Accept	Reject
	F.L.P.I. CARRIED OUT ON 100% OF EXTERNAL SURFACE OF: 212/205 HIGH FED X-TUBES JOB# 35893		
	206B AFT X-TUBES JOB #'S 36051 (35725)		
	206L FWD X-TUBES JOB#'S 36053, 36055		
	206L AFT X-TUBES JOB #'S 36057, 36059, 36056		
	RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH GRINDING MARKS. TO BE POLISHED AND RECHECKED AT A LATER DATE.		
	ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/ QSI-038 STANDARD.		

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative

Technician (Signature):

Name (Print):

FREDERICK CHAGNON

CGSB Level II SNT Level
CGSB Reg. No 10560

signature

BRENDON MIRAN

CGSB Level II SNT Level
CGSB Reg. No 12247

DTR #

Report

Reviewed by:

Name

initials

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